



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 177210



Part No: D2563

Job Qty: 1 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	6/18/18	6/18/18	0.00	0.00	Start Up Large Fab-2	24	DAS
100	Large Fab	8 pcs	6/18/18	6/18/18	0.00	11.76	Large Fab 2	24	DAS
110	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC9	9-89	9-89
120	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC5		9-89
130	HandFinish	8 pcs	6/18/18	6/18/18	0.00	2.15	HandFinish1		SA 18-07-05
140	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC7		CPL
150	Large Fab	8 pcs	6/18/18	6/18/18	0.00	11.76	Large Fab 2		18-18-7-11
160	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC10		CPL
170	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC5		CPL
175	HandFinish	8 pcs	6/18/18	6/18/18	0.00	2.15	HandFinish2		SA 18-07-11
180	Powdercoat	8 pcs	6/18/18	6/18/18	0.00	1.33	Powdercoat1		18-18-7-11
190	HandFinish	8 pcs	6/18/18	6/18/18	0.00	2.15	HandFinish3		18-18-7-11
200	QC	8 pcs	6/18/18	6/18/18	0.00	0.00	QC3		JUL 26 2018
210	Packaging	8 pcs	6/18/18	6/18/18	0.00	0.00	Packaging3		JUL 26 2018
220	QC21-SA	8 Ea	6/18/18	6/18/18	0.00	0.00	QC21		JUL 26 2018

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & DESCRIPTIONS: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M138839 START: 3:20 O.V.T. 3:20 FINISH: 3:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	8 Ea (1 ea)	90-Start up Operation	B64533
D2561	Lug	16 Ea (2 ea)	90-Start up Operation	5068735
D2564	Mounting Angle	16 Ea (2 ea)	90-Start up Operation	5084940
D2673-34	End Plate	8 Ea (1 ea)	90-Start up Operation	5078838
D2673-34	End Plate	8 Ea (1 ea)	150-Large Fab	5078838

ming walk 5080995

004221

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	8	67	0
	D2561	16	22	0
	D2564	16	1	0
	D2673-34	8	32	0
150-Large Fab	D2673-34	8	32	0
Part Specifications				
Specifications could not be found.				

Plex 5/8/18 11:52 AM Dart.Gagnon.Michelle

DART
AEROSPACE

Container No: S089202

Part: D2563
Job No: 177210
Serial No/Batch: S089202

Revision:
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/04/18